

Work Order ID 74486

Monday, October 03, 2011 10:41:37 AM



Page 1

Item ID: D3622-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ball Stud

Start Date: 9/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3622

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622,
FOLIO REV: AK
DWG REV: AK
2-DEBURR AS REQUIRED

40 ϕ AK 11/10/18

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

40 ϕ AK 11/10/18

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 11/10/19

40 ϕ _____

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 870

0.00



Packaging

Memo

0.00

Packaging

Sp 11-10-19

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19
cmf
11-10-19

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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 10:41:42 AM

Page 1

Work Order ID: 74486

Parent Item: D3622-1

Parent Item Name: Ball Stud





Start Date: 9/30/2011

Required Date: 10/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500  303 HEX BAR .500		Purchased	No			100	f	65.5300	0.108 	4.547368 4.8375		11/10/18	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT037	65.53						
						109778	65.53						
										4.8375			

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74486
Description: Ball Stud		Part Number: D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	0.5635	✓		SL08	
0.50	+/-0.030	0.499	✓		SL08	
Ø0.394	+/-0.010	Ø0.3892	✓		SL02	
Ø0.310	+/-0.010	Ø0.3105	✓		SL08	
Ø0.215	+/-0.010	Ø0.224	✓		SL08	
0.155	+/-0.010	0.157	✓		SL08	
0.313	+/-0.010	0.308	✓		"	
0.478	+/-0.010	0.470	✓		"	
0.630	+/-0.010	0.630	✓		"	
0.125	+/-0.010	0.122	✓		"	
0.563	+/-0.010	0.555	✓		"	
1.19	+/-0.030	1.180	✓		"	
0.3125-24UNF-3A	+0.000/-0.072	0.3125-24 _{UNF}	✓		"	
M.O.W.	Min = 0.3336 Max = 0.3363	0.3354	✓		SL02	

Measured by: <i>[Signature]</i> Date: 11/10/18	Audited by: H.A. Date: 11/10/19	Preliminary Approval: Date:
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Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ <i>[Signature]</i>	<i>[Signature]</i>

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WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

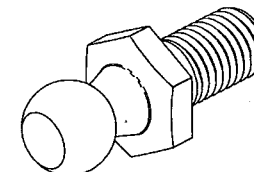
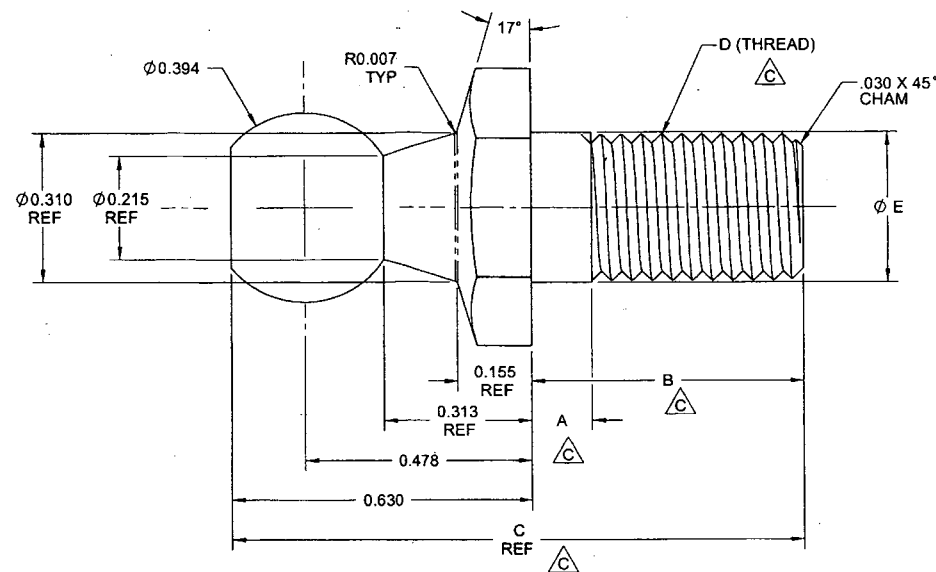
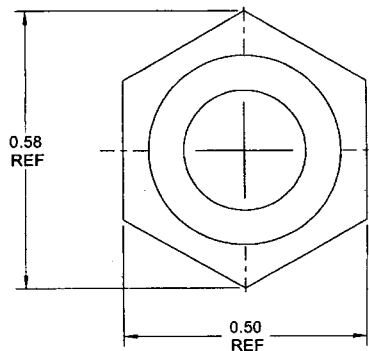
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

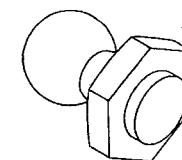
WORK ORDER NON-CONFORMANCE (NCR)

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NOTE: Date & initial all entries



**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

RELEASED
2010-09-23

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74486 M.L.J
11/10/03

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN	Ø E MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. REV. C	
CHECKED		D3622 SHEET 1 OF 1	
MFG. APPR.		TITLE SCALE	
APPROVED		BALL STUD NTS	
DE APPR.		DATE 10.07.20	
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